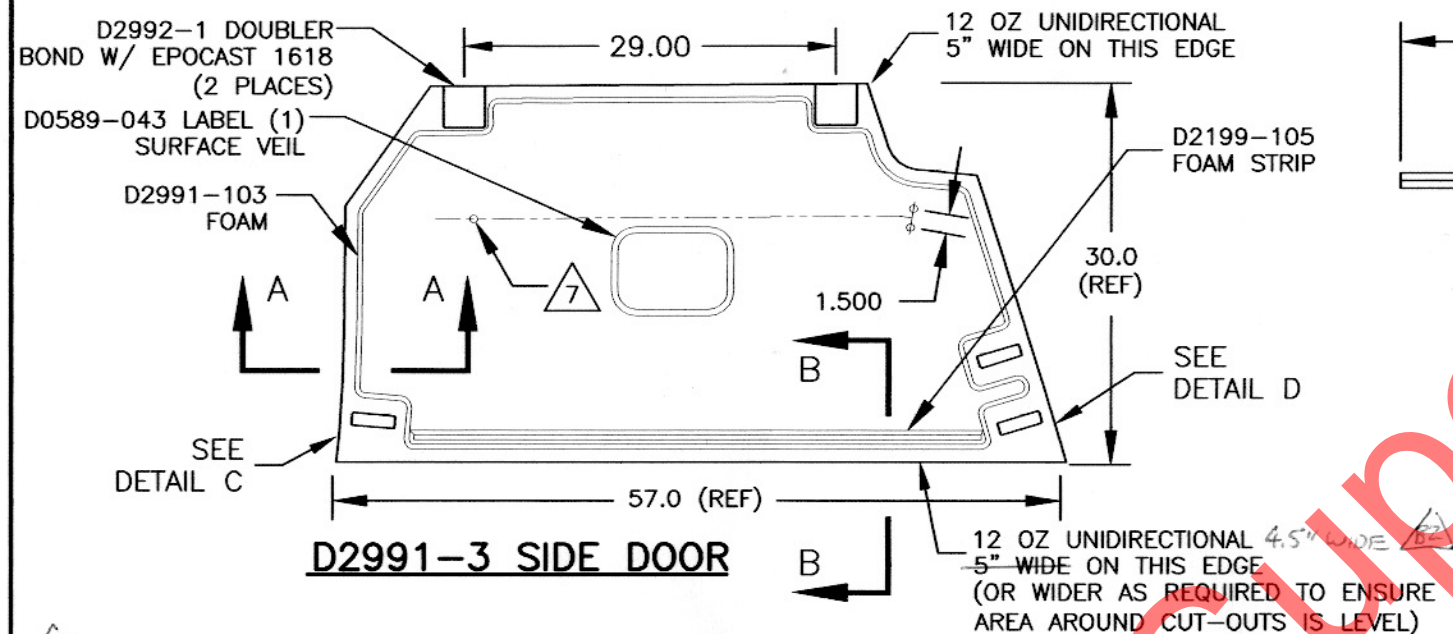
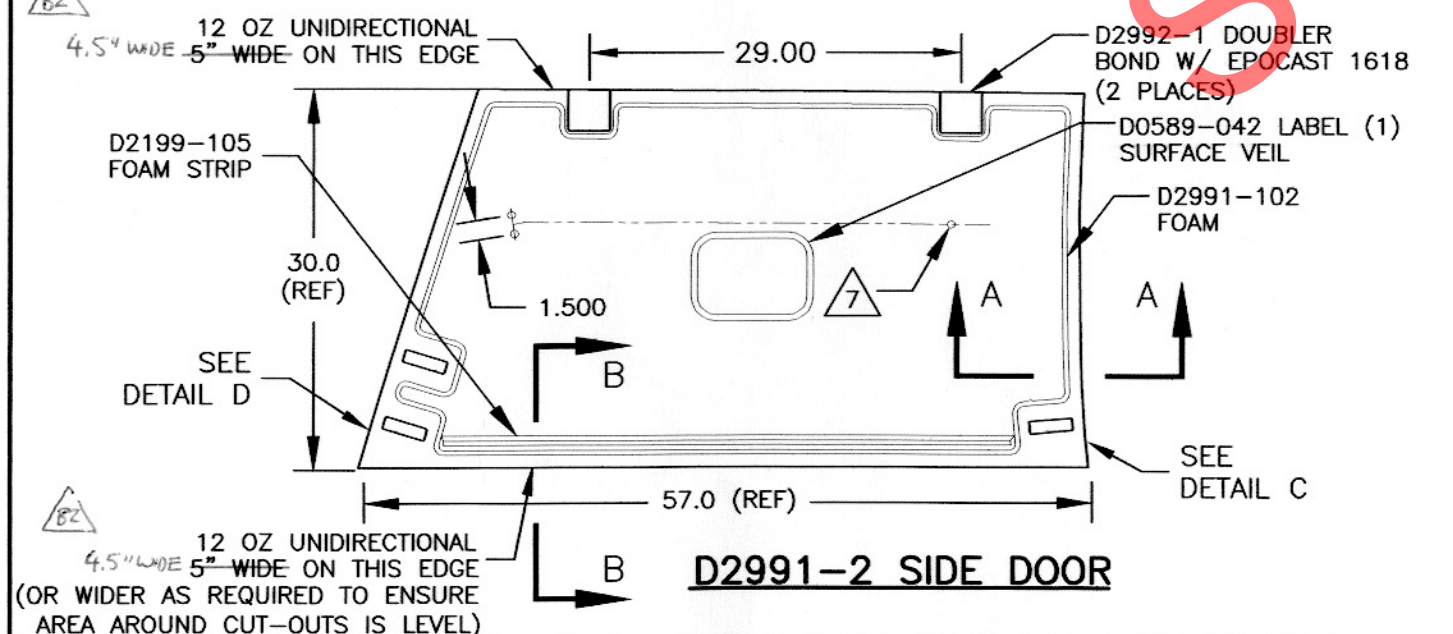


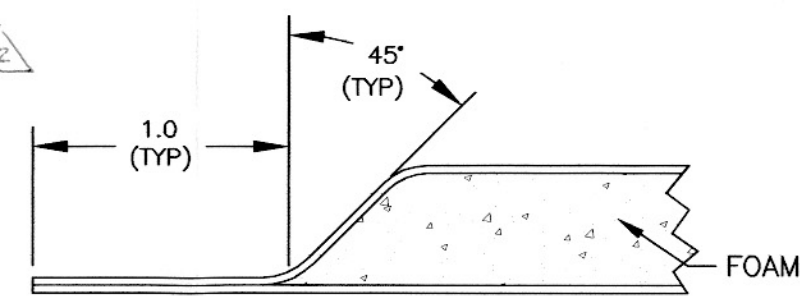
D2991-1 SIDE DOOR



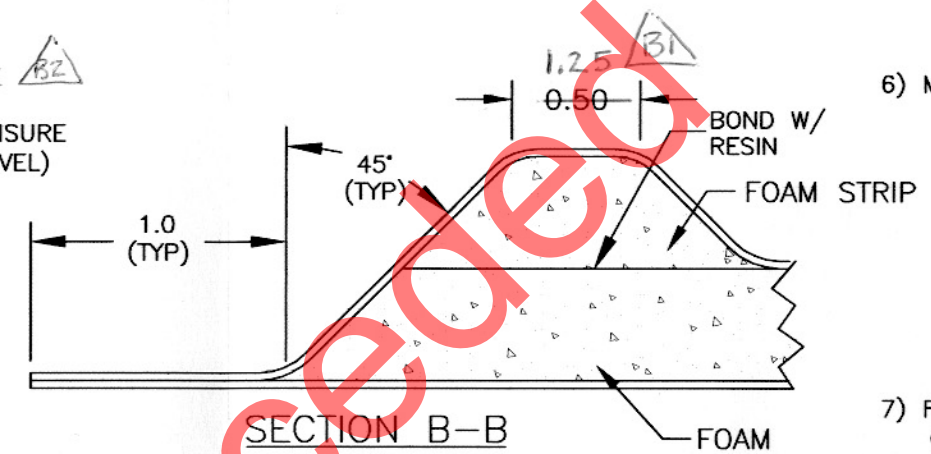
D2991-3 SIDE DOOR



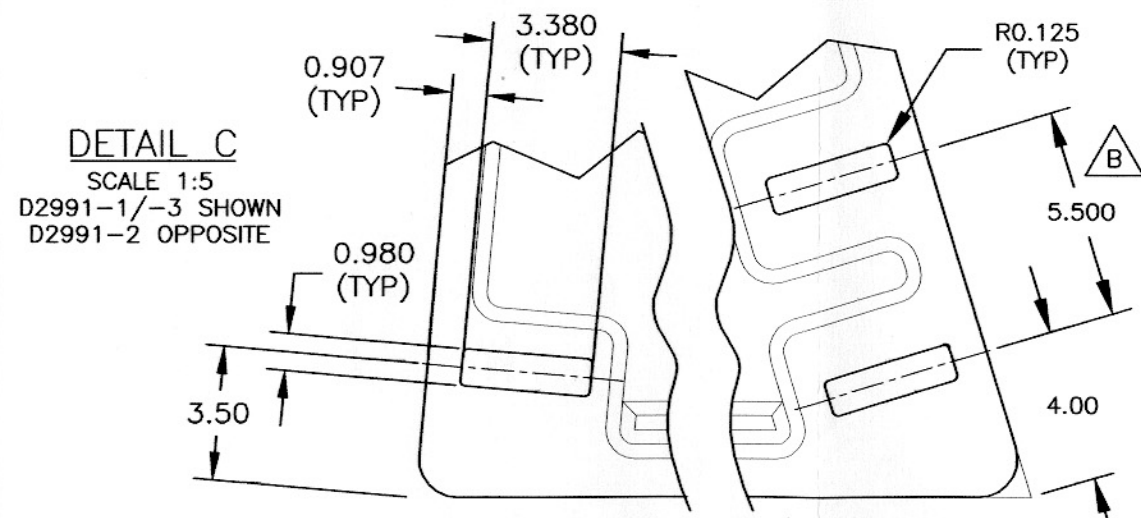
D2991-2 SIDE DOOR



SECTION A-A
NOT TO SCALE
D2991-1/-3 SHOWN
D2991-2 OPPOSITE



SECTION B-B
ONE EDGE ONLY
NOT TO SCALE, VIEW ROTATED
D2991-1/-3 SHOWN
D2991-2 OPPOSITE



DETAIL C
SCALE 1:5
D2991-1/-3 SHOWN
D2991-2 OPPOSITE

DETAIL D
SCALE 1:5
D2991-1/-3 SHOWN
D2991-2 OPPOSITE

- NOTES FOR D2991-1/-2/-3**
- 1) LAYUP PER QSI 006 AND AS FOLLOWS
 - 2) MATERIAL:
RESIN: EPOCAST 50-A/9816
FOAM: KLEGECELL R-75, 0.375" (9.52mm) THICK
FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
 - 3) FINISH INSIDE WITH EPOXY PRIMER GREY #16473 4500-PB-40B
 - 4) USE MOLD DT8626 FOR D2991-1 SIDE DOOR
USE MOLD DT8627 FOR D2991-2 SIDE DOOR
USE MOLD DT8626 FOR D2991-3 SIDE DOOR (TRIM PER DT8631)
 - 5) ROUTER FOAM CORE USING:
DT8628 FOR D2991-1 SIDE DOOR
DT8629 FOR D2991-2 SIDE DOOR
DT8630 FOR D2991-3 SIDE DOOR
 - 6) MAIN LAYUP:
949 SANDING GELCOAT
9 OZ SATIN
9 OZ SATIN
FOAM
FOAM STRIP
9 OZ SATIN
12 OZ UNIDIRECTIONAL (5" WIDE, 2 EDGES SHOWN)
9 OZ SATIN
RESIN (35-45% BY WEIGHT)
PEEL PLY
 - 7) FILL WITH RESIN. FINISH WITH EPOCAST 1618. DRILL TO Ø0.191, 3 PLACES PER DOOR.
 - 8) ALL DIMENSIONS ARE IN INCHES
 - 9) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
02.02.22

COPYRIGHT © 2002 BY DART AEROSPACE LTD.			
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			
DESIGN	CP	DRAWN BY	CP
CHECKED	J	APPROVED	J
DATE	02.02.22	TITLE	SIDE DOOR
		DART AEROSPACE LTD.	REV. B
		HAWKESBURY, ONTARIO, CANADA	
		DRAWING NO.	D2991
		SHEET 1 OF 1	
		SCALE	1:15